

Date: Tuesday, 21/11/2006 1:42:34 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARSHOE
Job Number	29336	Part Number	D265623
Estimate Number	10615	Drawing Number	D2656 REV D
P.O. Number	N/A	Project Number	N/A
This Issue	21/11/2006	S.O. No.	N/A
Prsht Rev.	NC	Drawing Revision	D
First Issue	N/A	Material	N/A
Previous Run	29336	Due Date	28/11/2006
Written By		Qty:	20
Checked & Approved By		Um:	Each
Comment	Est: 02.10.25, Re-format KJ		

Additional Product

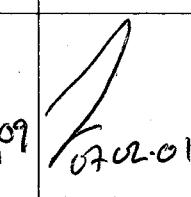
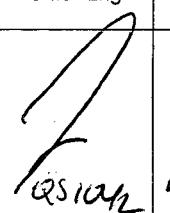
Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M1010S20GA	1010/1025/A21/6aA SHEET Comment: Qty.: 1.0605 sf(s)/Unit Total: 21.2100 sf(s) 1010/1025/A21/6aA SHEET <i>m 103258</i> <i>m 07 02 01</i> <i>20</i>
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET <i>m 07 02 01</i> <i>20</i> <i>PTO</i>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL- & MEDIUM FAB RESOURCE 1 Deburr if necessary. <i>SB</i> <i>John</i> <i>07/02/06</i> <i>19</i>
4.0	BRAKE NC	NC BRAKE Comment: NC BRAKE <i>SB</i> <i>07/02/06</i> <i>19</i>
5.0	QC5	INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP <i>John 02-09</i> <i>19</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/02/05	2.1	QC 2		permanent change	SAD	07/02/05	20		07/02/05
	2.2	QC 8		permanent change	QA	07/02/05	20	07/02/05	07/02/05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/02/05
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
07/02/05	2.0	Part cut by water jet. Pressure water still coming out of tip, when tip went bevoss the part. Machine malfunction.	 QA1042	Scrap & destroy. No replace	SB 07/02/05	 07/02/05	 QA1042	 07/02/05	

NOTE: Date & initial all entries

Date: Tuesday, 21/11/2006 1:42:34 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 29336

Part Number: D265623

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING POWDER COATING



M1101601



(19x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m. R / yl

07/02/09

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



PC 7/02/09 (19)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP18

yl pte 07/02/09 x19

9.0 QC21 FINAL INSPECTION/W/O RELEASE



(81)

Comment: FINAL INSPECTION/W/O RELEASE

SD 07/02/09

Job Completion



W 07-02-09

Date: Monday, 11/6/2006 2:39:36 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARSHOE		
Job Number	29336			Part Number	: D265623		
Estimate Number	10615			Drawing Number	: D2656 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	11/6/2006			Drawing Revision	: D		
Prsht Rev.	NC			Material	:		
First Issue	/ /			Due Date	: 11/20/2006		
Previous Run	24846			Qty:	20	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	Est: D 02.10.25 Re-format KJ						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		<i>W/ Rejekt</i>
	Comment: PURCHASING	
	Issue P/O: _____	
	Email or ship DXF file to vendor	
	Laser Cut per Dwg D2656 flat pattern D2656-23	
	Material release note required	
2.0	D265623F	Wearplate
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)	
	Wearplate	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Receive & Inspect For Transit Damage	
	Ensure material release note is attached	
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	
	Inspect dimensions per template D2656-23T1	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Deburr if necessary.	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:39:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 29336

Part Number: D265623

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D2656 using Jig DT8158

3-Identify as D2656-23

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1.

Identify and Stock

Location: _____

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

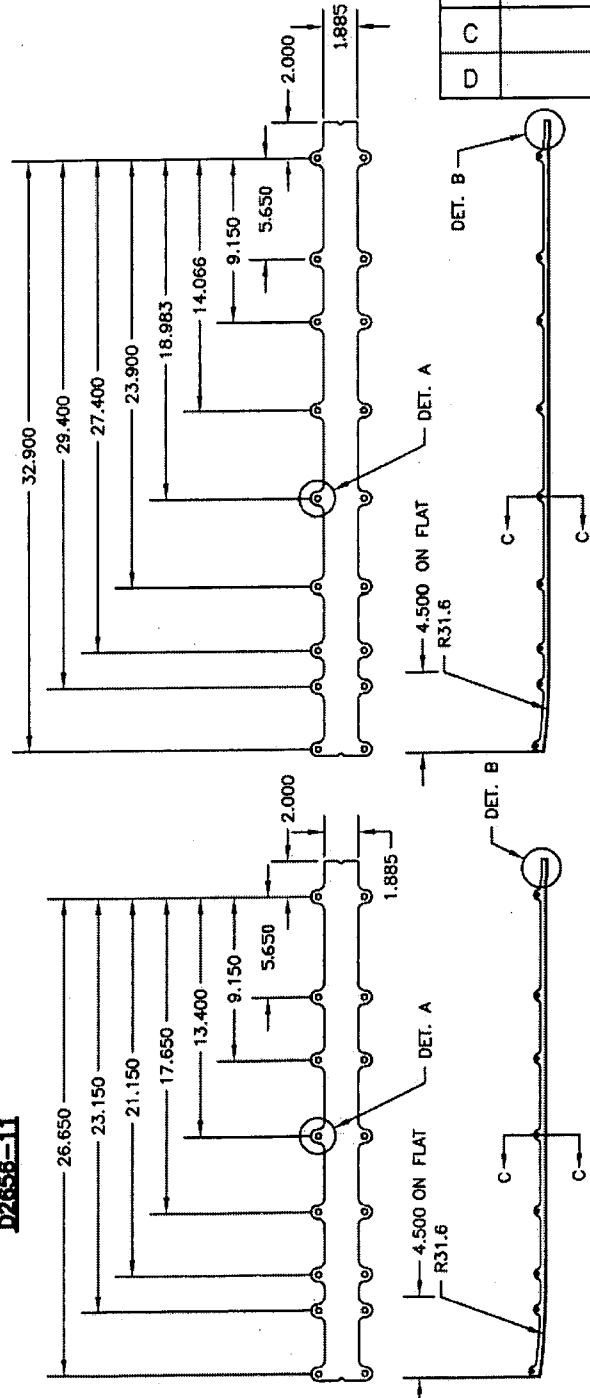
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

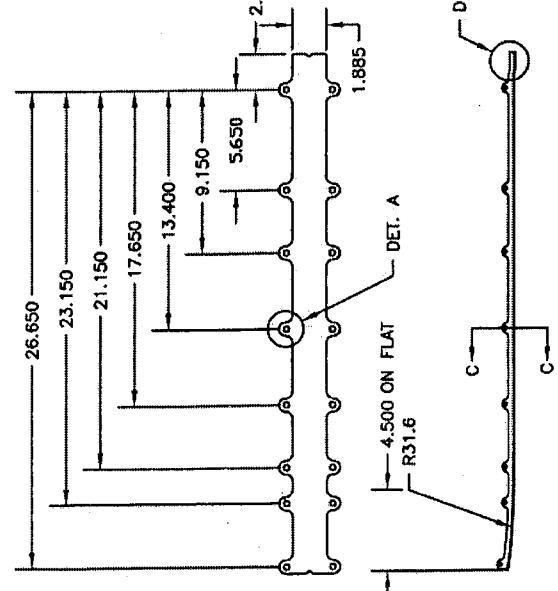
DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2656 REV. D SHEET 1 OF 4
DATE	TITLE	SCALE
05.08.17	WEARSHOE	1:10

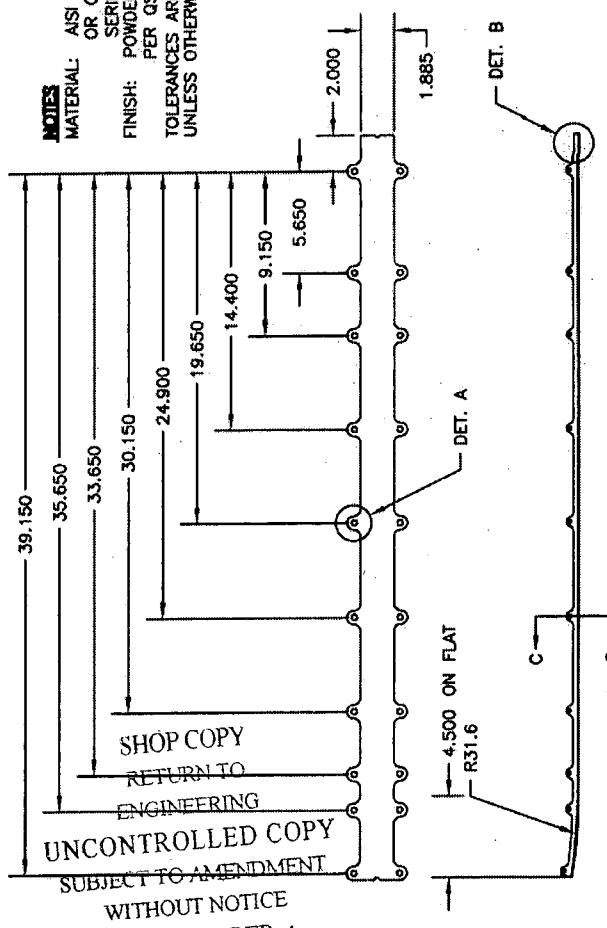
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D2656-11



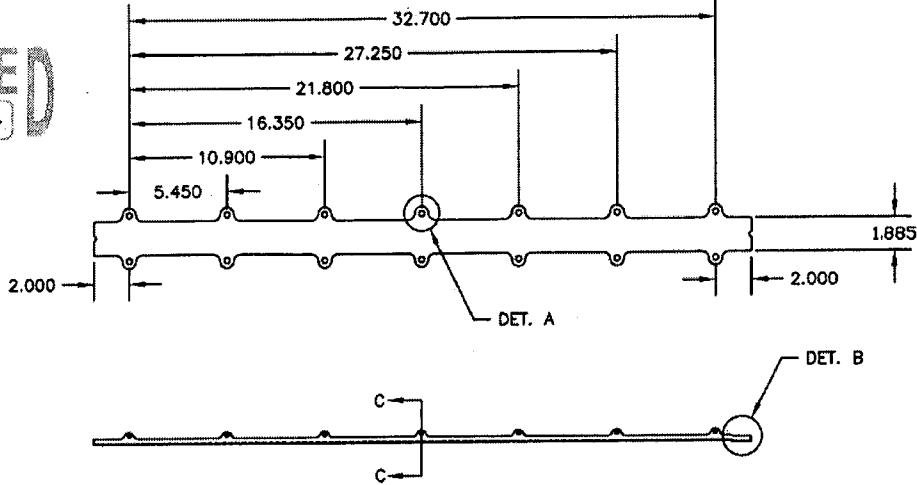
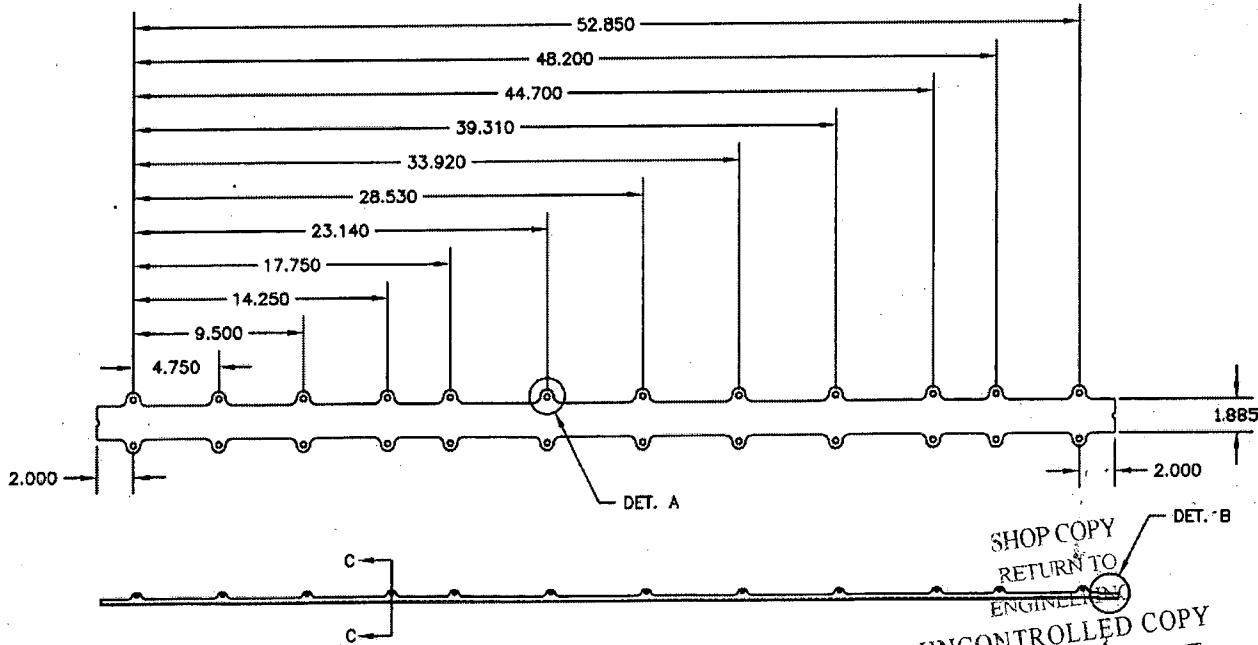
D2656-15



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DATE		REV. D SHEET 2 OF 4
05.08.17		TITLE WEARSHOE SCALE 1:10

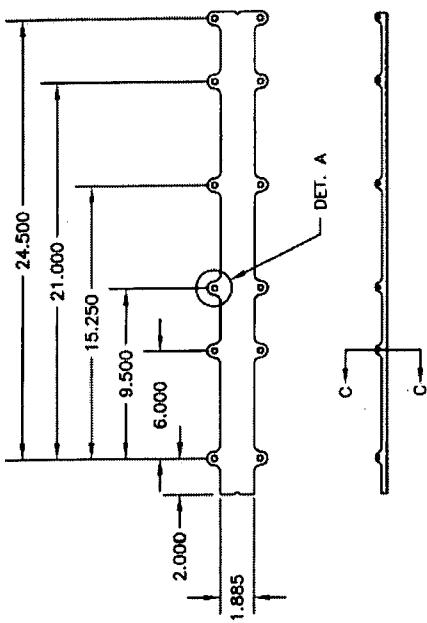
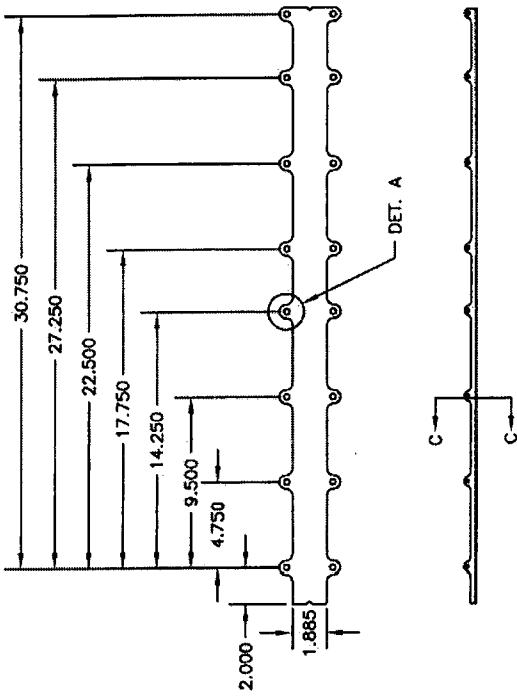
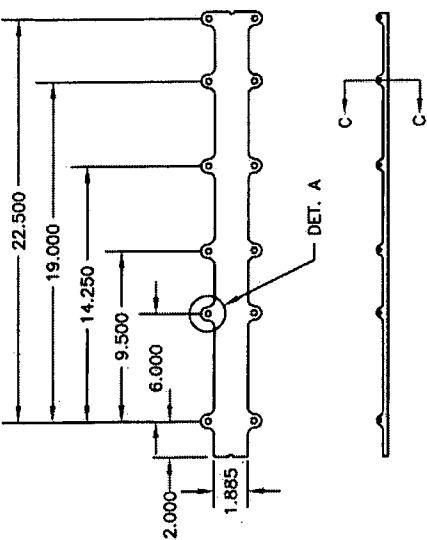
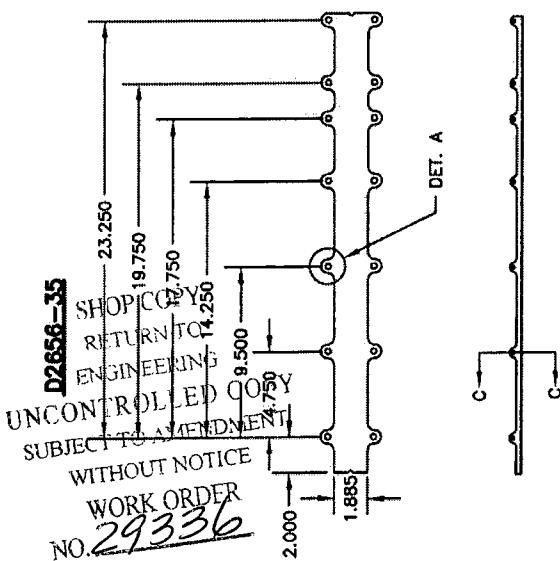
D2656-21**RELEASED**
05.07.06D2656-23**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

SHOP COPY
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WORK ORDER
NO. 29336

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DS	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. REV. D
		D2656
DATE		SHEET 3 OF 4
05.08.17		WEARSHOE
		SCALE
		1:10

D2656-33**D2656-37****RELEASED**
05-07-06**D2656-31****D2656-35**

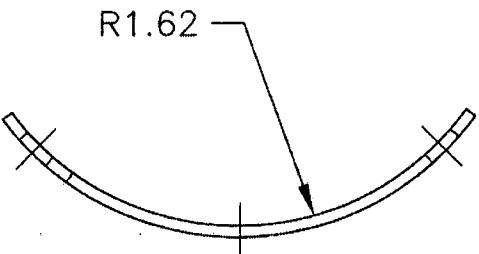
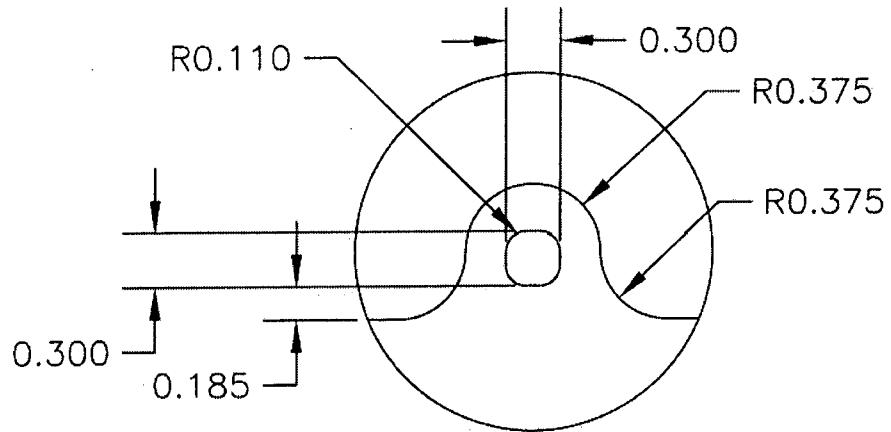
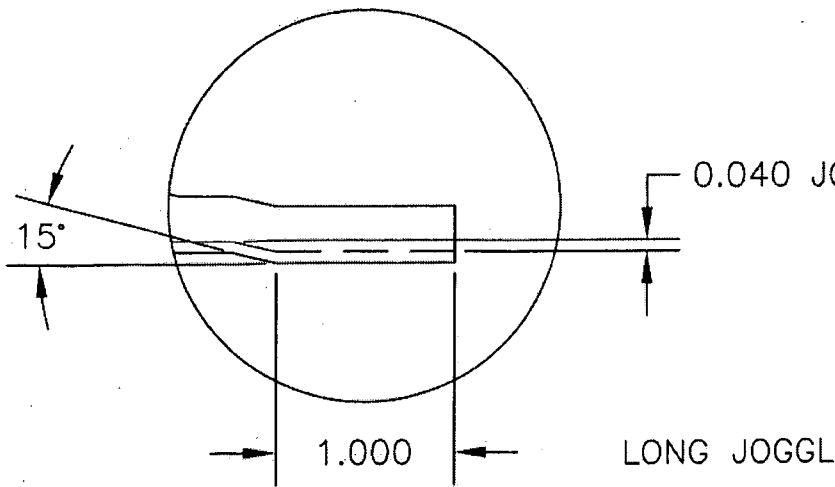
NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES: STEEL, 20 GAUGE (0.040 THICK)
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DESIGN DS	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

SECTION C-C**RELEASED**
05.09.06 *[Signature]*DETAIL ADETAIL B

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WORK ORDER
NO. *29336*

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DART AEROSPACE LTD	Work Order:	29336
Description: Wear shoe	Part Number:	D2656-23
Inspection Dwg: D2656 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<i>MM</i>	Audited by:	<i>MM</i>	Prototype Approval:	
Date:	07/02/01	Date:	<i>07/02/05</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Jason Murdoch

From: S Shahbazian [sshahbazian@dartaero.com]
Sent: Thursday, January 25, 2007 8:20 AM
To: 'L Lacelle'; *David Shepherd (*David Shepherd); 'Peter Hum (Peter Hum)'
Cc: 'Jason Murdoch'
Subject: RE: 1010 STEEL FOR WEARPLATES

I don't see problem of using .029 thicknesses instead of .036 for wearplates, unless David sees a problem.

Thanks
Serge

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 25, 2007 8:17 AM
To: 'S Shahbazian'; *David Shepherd (*David Shepherd); 'Peter Hum (Peter Hum)'
Cc: 'Jason Murdoch'
Subject: RE: 1010 STEEL FOR WEARPLATES

Any news on this??

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: January 23, 2007 4:51 PM
To: 'L Lacelle'; *David Shepherd (*David Shepherd); 'Peter Hum (Peter Hum)'
Cc: 'Jason Murdoch'
Subject: RE: 1010 STEEL FOR WEARPLATES

Linda,

Do we know all the variable sizes that those sheets are coming in? The decision to accept the various thicknesses is depending on where the sheets are used. For example in this case it is used for wearplates which I think it is ok; however we have to see where else it will be used. In other words depends on the application.

Thanks
Serge

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 23, 2007 10:48 AM
To: *David Shepherd (*David Shepherd); S Shahbazian; Peter Hum (Peter Hum)
Cc: Jason Murdoch
Subject: 1010 STEEL FOR WEARPLATES

We are getting a lot of variances in tolerances on the steel mat'l we purchase for wearplates. Is there a standard tolerance for this mat'l? the 20ga we just rec'd should be about .036 – but we are getting .029 – is this acceptable. We have had this discussion before, but no one came back with a tolerance we can use to check this mat'l. Can anyone help?

LL

